

Date: Monday, 23/02/2009 3:30:04 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INSTRUMENT PANEL ASS'Y
Job Number : 46021	
Estimate Number : 13352	
P.O. Number :	Part Number : D3705041
This Issue : 23/02/2009 S.O. No. :	Drawing Number : D3705 REV.C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 41224	Material :
Written By :	Due Date : 15/03/2009 Qty: 4 Um: Each
Checked & Approved By : <u>STU 090224</u>	
Comment : Est Rev:A new issue 08-05-30 DD verified by:ec Est rev:B 09-01-09 rev.C as per dwg DD verified by:ec Est Rev:C 09-01-15 rivet chg DD verified by:EC Est Rev:D 09-02-20 rev.c as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 D33351 Short Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Short Spring

batch: B347513 x2 B345179 x2

2.0 D3705043 Instrument Panel Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Instrument Panel Weldment

batch: B346202

3.0 D37055 Access Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Access Panel

batch: B346203

4.0 D37065 Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pin

batch: B346111

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/02/2009 3:30:05 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INSTRUMENT PANEL ASS'Y

Job Number: 46021

Part Number: D3705041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D37073

MOUNTING LUG



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

MOUNTING LUG

batch:

B44277 x4 B410112 x4

SS 09/06/04 x4

6.0

AN526C1032R6

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Screw

batch:

M1892

SS 09/06/04 x4

7.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

batch:

M111279

SS 09/06/04 x4

8.0

MS171498

Spring Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spring Slotted Pin

batch:

M108521

SS 09/06/04 x4

9.0

CR1122 3 025

RIVET



Comment: Qty.: 28.0000 Each(s)/Unit Total: 112.0000 Each(s)

RIVET

batch:

M106878 x13 M110849 x22
M111293 x77

SS 09/06/04 x4

10.0

MS21075L3

Nutplate



Comment: Qty.: 14.0000 Each(s)/Unit Total: 56.0000 Each(s)

Nutplate

batch:

M110704 x38 M111477 x18

SS 09/06/04 x4

11.0

MS24693C272

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Screw

batch:


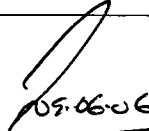
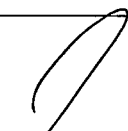

M18815

SS 09/06/04 x4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/06/04	7.0	AN960JD416 washer does not fit over top of the D3706-5 pin (0.313 OD). RC: Drawing		USE AN960JD516 washers Qty 4 per W/O m 11279	FT 09/05/06	 09.06.06		
			05/11/12	update drawing.			05/11/12	09.06.04.

NOTE: Date & initial all entries

Date: Monday, 23/02/2009 3:30:05 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INSTRUMENT PANEL ASS'Y

Job Number: 46021

Part Number: D3705041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble parts as per dwg D3705

FF 09-06-04 (4)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-06-06 (9)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: 163

9/6/8

Handwritten signature/initials

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/09

Job Completion



mf 09-06-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

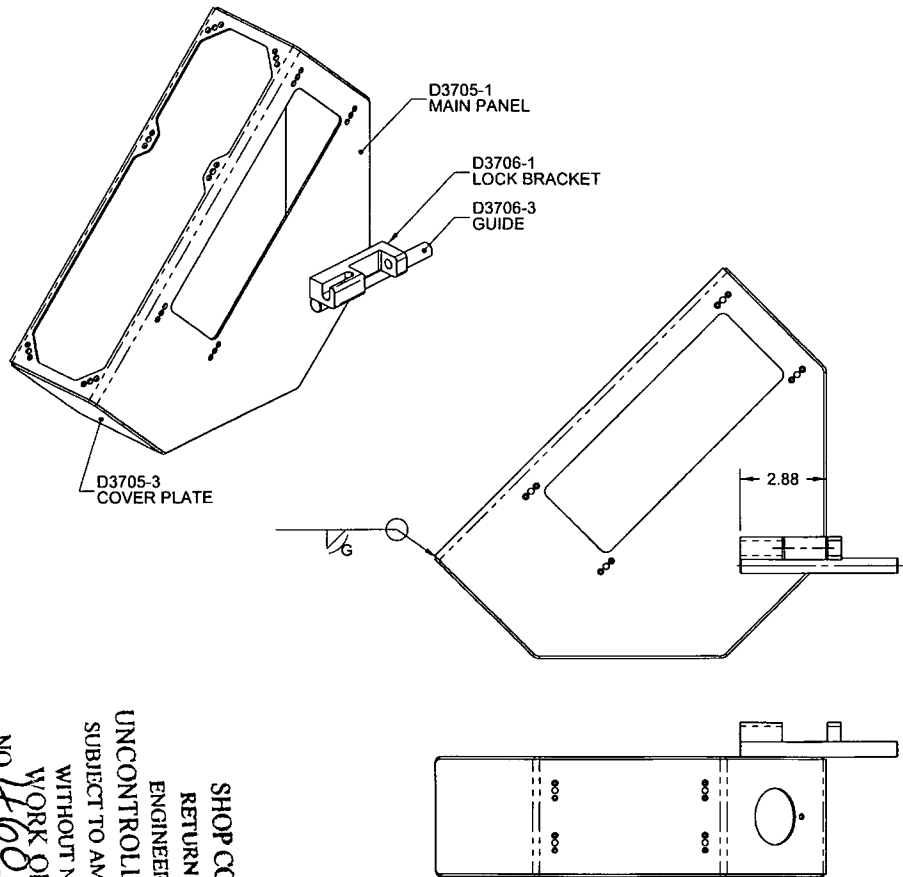
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	-043 QTY.	P/N	DESCRIPTION
1	X	D3705-043	INSTRUMENT PANEL WELDMENT
3	1	D3705-1	MAIN PANEL
4	1	D3705-3	COVER PLATE
5	1	D3706-1	LOCK BRACKET
6	1	D3706-3	GUIDE



D3705-043 INSTRUMENT PANEL WELDMENT

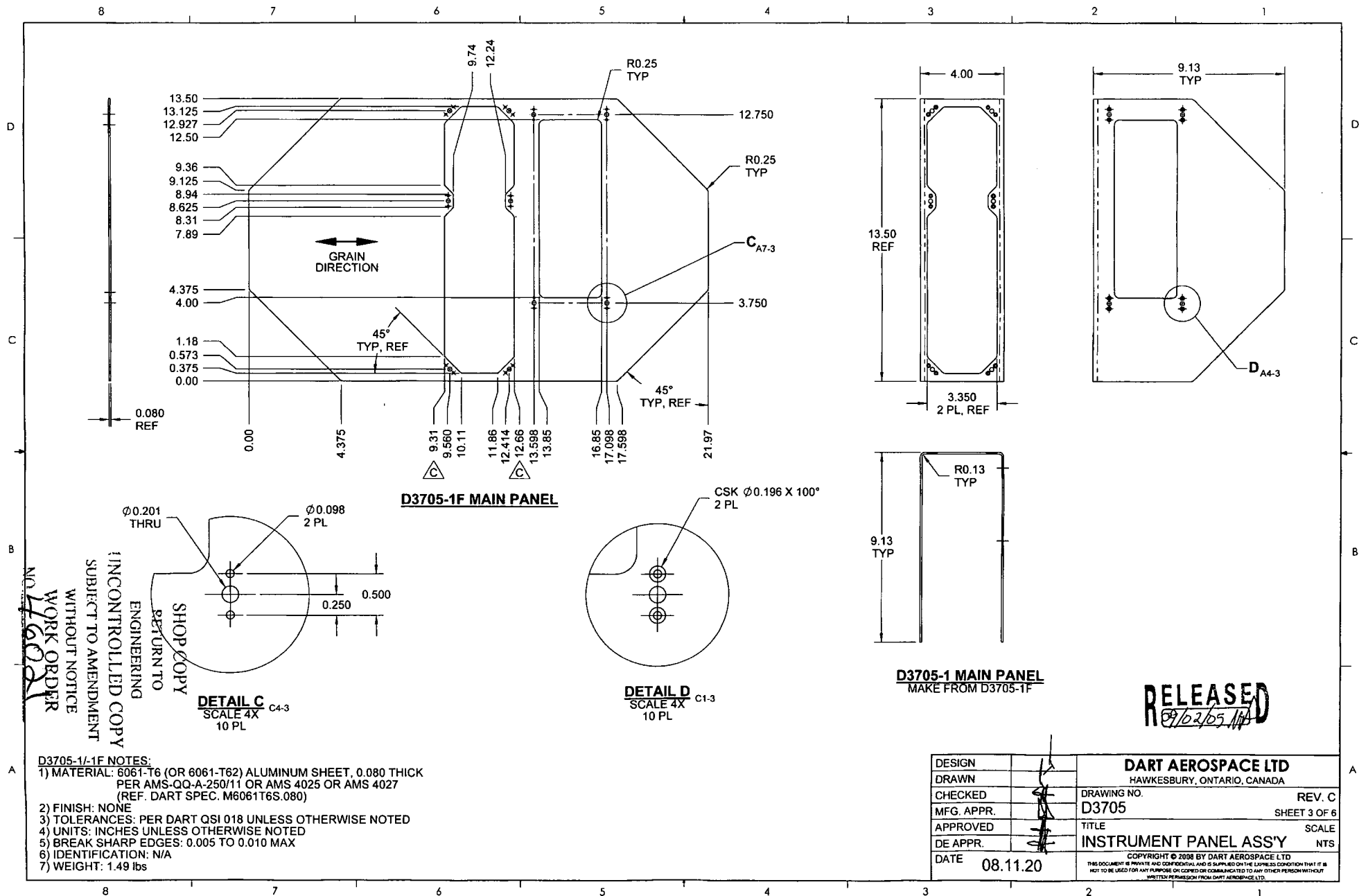
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WITHOUT NOTICE
WORK ORDER
NO 40021

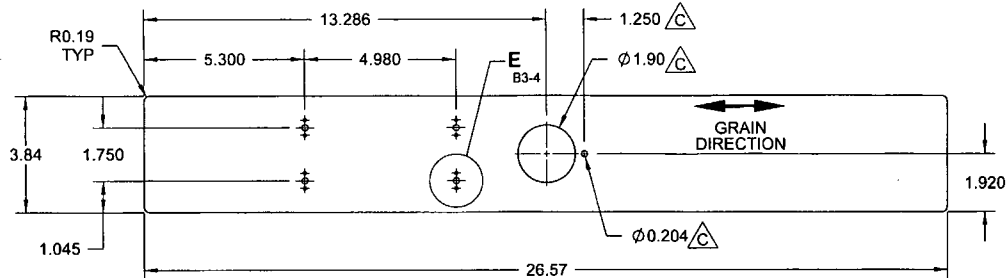
D3705-043 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.90 lbs
- 8) WELDING: PER DART QSI 004

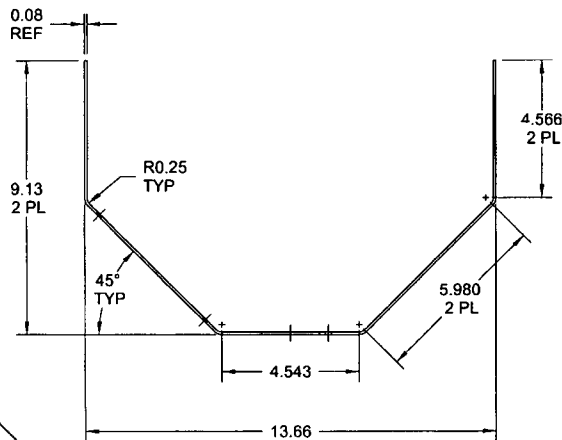
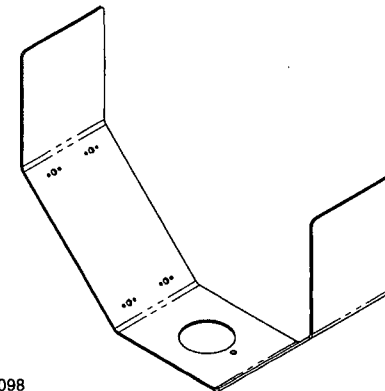
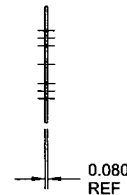
RELEASED
09/02/05 MAB

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3705	REV. C
MFG. APPR.		TITLE	SHEET 2 OF 6
APPROVED		INSTRUMENT PANEL ASS'Y	SCALE
DE APPR.			NTS
DATE	08.11.20	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

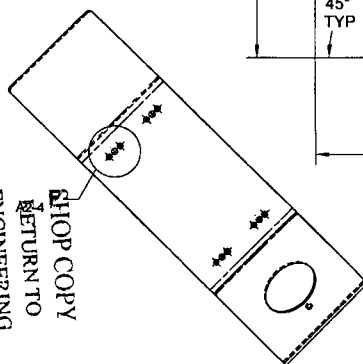
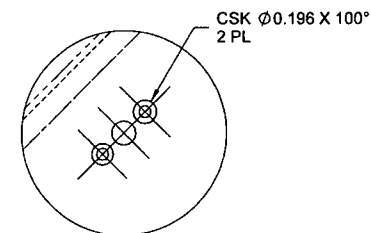
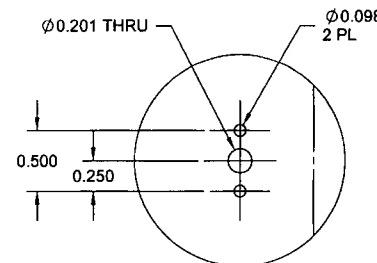




D3705-3F COVER PLATE FLAT PATTERN



**D3705-3 COVER PLATE
(MAKE FROM D3705-3F)**



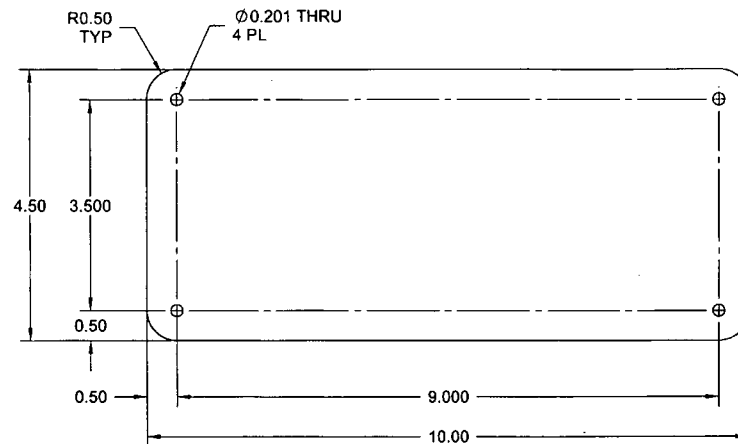
NO. 470021
WORK ORDER
WITHOUT NOTICE
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D3705-3/-3F NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.77 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3705	SHEET 4 OF 6
MFG. APPR.		TITLE	SCALE
APPROVED		INSTRUMENT PANEL ASS'Y	
DE APPR.			NTS
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RELEASED
07/02/05



D3705-5 ACCESS PANEL

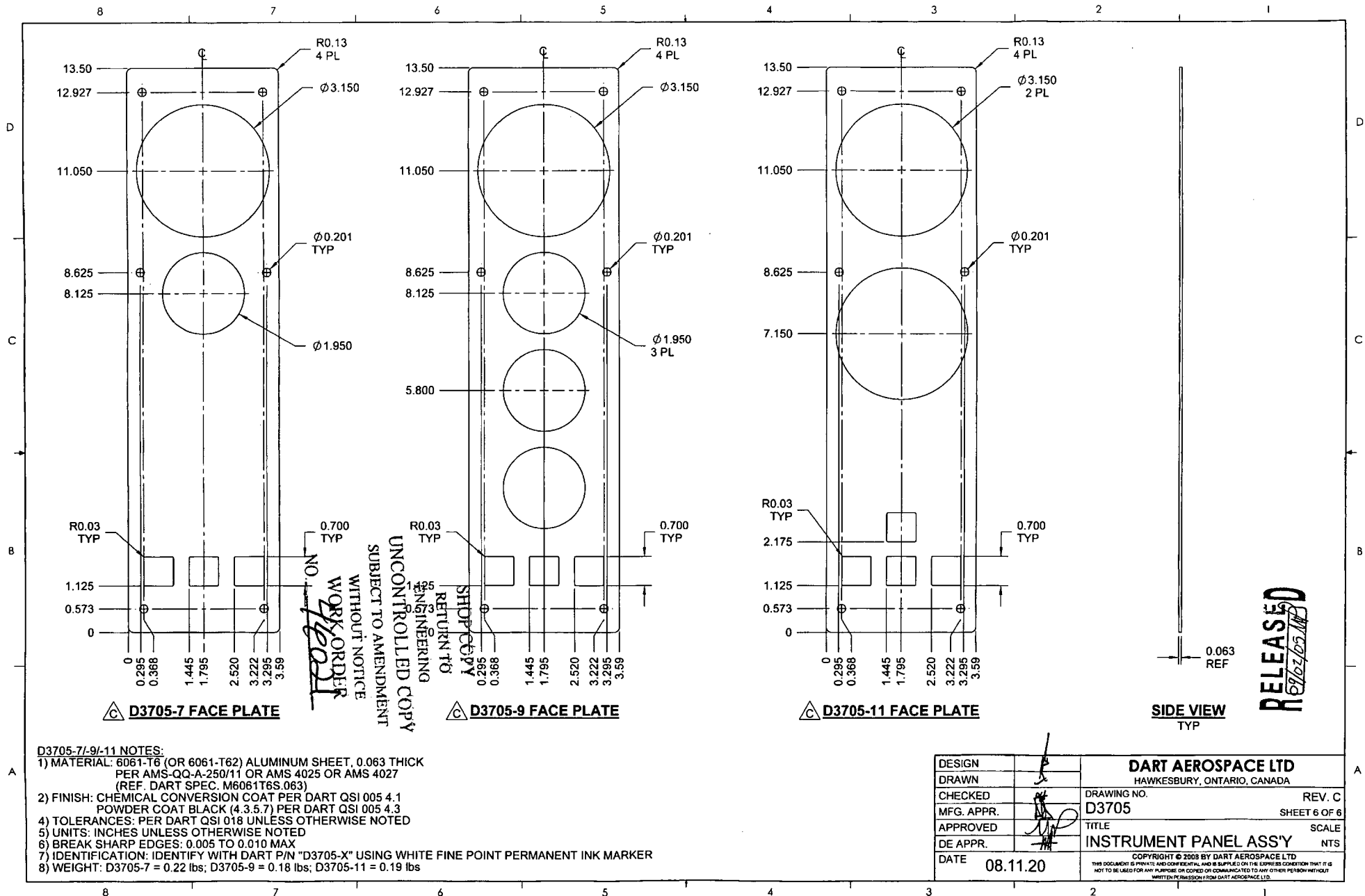
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WORK ORDER NO. 40821

D3705-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-5" USING WHITE FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.17 lbs

RELEASED
9/24/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3705	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASS'Y NTS	
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D3705-7/-9/-11 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-X" USING WHITE FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: D3705-7 = 0.22 lbs; D3705-9 = 0.18 lbs; D3705-11 = 0.19 lbs

NO. 1425
WORK ORDER
474001
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